

Date: Thursday, 22/01/2009 8:03:20 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSY WELDMENT
Job Number	: 45045		
Estimate Number	: 13503		
P.O. Number	:	Part Number	: PB674300109
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.6
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 45044	Material	:
Written By	:	Due Date	: 28/02/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Square Tubing

batch:- 344989

MF 09-02-02

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tubing

batch:- 343073

MF 09-03-02

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Square Tubing

batch:- 41484

MF 09-03-02

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tube

batch:- 41907

MF 09-03-02

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Square Tube

batch:- B 41917

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:03:20 AM
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Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- 41490

MF 09-03-02

7.0

PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Outer Tube

batch:- 41489

MF 09-03-02

8.0

PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Flanged Hook

batch:- B 21000 x 4

MF 09-03-02

9.0

PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Restraint

batch:- B41602

MF 09-03-02

10.0

PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Contoured Hinge Arm

batch:- B41499

MF 09-03-02

11.0

PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Handle Arm Extension

batch:- B 43232 40044

MF 09-03-02

12.0

D34409

Tube Detent Clip Base (Supersedes B67-43)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Tube Detent Clip Base

batch:- B 41205

MF 09-03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket (Supersedes B67-43001-273)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

batch:- B41201

MF 09-03-02

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

09-03-010 2

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-11(2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0903.11 (2)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

BR 09-03-12

(2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M- 09/03/12 (2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: misc

PL 09.03.12 (x2)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



②
H 09/03/13
MF
09-03-13

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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